



Dart Hawkesbury
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D412-742-023
Job Sheet 168529



Part No: D412-742-023

Job Qty: 1 pcs

Part Name: Float Skidtube Installation (Dart Tri-Bag)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/16/17

Job Tracking No:

Due Date: 12/29/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea	12/29/17	12/29/17	0.00	0.00	Start Up Container			FEB 0 1 2018
110	Packaging	1 pcs	12/29/17	12/29/17	0.00	0.00	Packaging1			FEB 0 1 2018
120	QC	1 pcs	12/29/17	12/29/17	0.00	0.00	QC4			SMS
125	DC	1 pcs	12/29/17	12/29/17	0.00	0.00	DC			SMP
130	Packaging	1 pcs	12/29/17	12/29/17	0.00	0.00	Packaging3			24 18-18
140	QC	1 pcs	12/29/17	12/29/17	0.00	0.00	QC21			-2-1 19074

Part Op 110 - NULL

Descriptions: 120 - NULL

125 - Photocopy bluefile and create labels per PPP D412-742-023 CHG001

130 - Identify and pack for shipping as per PPP D412-742-023 Location :FG083

140 - NULL

MCS FEB 0 2 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	AN3C46A	13	231	0	0
	AN4C47A	4	42	0	0
	AN4C52A	8	61	0	0
	AN4C6A	16	338	0	0
	AN4C7A	4	111	0	0
	AN6C12A	8	125	0	0
	D2747	4	142	0	0
	D2876	2	65	0	0
	D2877	2	54	0	0
	D3405-041	1	13	0	0
	D3405-043	1	14	0	0
	D3407-041	1	3	0	0
	D3456-1	1	21	0	0
	D3533-1	2	39	0	0
	D3672-3	32	796	0	0
	D3672-9	8	982	0	0
	D412-742-053	1	1	0	0
	D5446-1	24	50	0	0
	D5466-1	1	2	0	0
	D5467-1	1	2	0	0
	D5468-1	1	2	0	0
	D5469-1	1	2	0	0
	D5482-1	8	24	0	0
	D5482-3	2	6	0	0

5031462x1

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval _____
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Description Work Order Deviation

Job No: 168529

Mfg Date: 02/01/18

Packaging CHG001

Operation: Change No:

Revision:

Original Serial #: S037920

PART NO: D412-742-023

Float Skidtube Installation (Part Tri-Bag)



S037920

DART AEROSPACE

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 Hawkesbury, ON K64 1K7
 CANADA
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 Email: sales@dartaero.com
 www.dartaerospace.com

Completed By _____

and / Supervisor _____

Approval Verification _____

QA Coordinator Approval _____

tioned Wrong _____

side Dimensions _____

r/Under tolerance _____

: Incorrect _____

t Lost/Missing _____

t Moved _____

Drawing _____

Finish _____

Misread _____

Turning Sequence _____

Root Cause		
Environment ☐	No Re-verification ☐	Pressure, ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre N ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Ki ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : _____

D5513-1	6	160	0	0
MS21043-3	3	767	0	0
MS21043-4	28	851	0	0
NAS1149C0332R	75	3,444	0	0
NAS1149C0432R	32	1,158	0	0
NAS1149C0632R	8	149	0	0

Part Specifications

Specifications could not be found.

Plex 11/16/17 8:30 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

Master Unit 000304

Containers on Master Unit 000304				
Serial No	Part No	Customer Part No	Status	Quantity
S037410	AN3C46A		Allocated	13
S037407	AN4C47A		Allocated	4
S037913	AN4C52A		Allocated	8
S037385	AN4C6A		Allocated	16
S037381	AN4C7A		Allocated	4
S037379	AN6C12A		Allocated	8
S037373	D2747		Allocated	4
S037367	D2876		Allocated	2
S037364	D2877		Allocated	2
S037363	D3405-041		Allocated	1
S037362	D3405-043		Allocated	1
S037361	D3407-041		Allocated	1
S037357	D3456-1	D3456-1	Allocated	1
S037354	D3533-1		Allocated	2
S037344	D3672-3	D3672-3	Allocated	32
S037341	D3672-9		Allocated	8
S037914	D5446-1		Allocated	24
S037547	D5466-1		Allocated	1
S037545	D5467-1		Allocated	1
S037544	D5468-1		Allocated	1
S037543	D5469-1		Allocated	1
S037335	D5482-1		Allocated	8
S037337	D5482-3		Allocated	2
S037329	D5513-1		Allocated	6
S037328	MS21043-3	MS21043-3	Allocated	3
S037327	MS21043-4	MS21043-4	Allocated	28
S037324	NAS1149C0332R		Allocated	75
S037323	NAS1149C0432R		Allocated	32
S037322	NAS1149C0632R		Allocated	8

5.2 D412-742-023 (DART TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -023	Qty -053	Part Number	Description
	X		D412-742-023	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-053	FLOAT SKIDTUBE
		1	D412-742-055	WEARPLATE KIT
		1	D5425-043	FLOAT SKIDTUBE ASSY.
1		*6	*D3672-1	*WASHER
2		30	D5513-1	BUSHING
3		*12	*D5512-1	*CROSSBOLT SPACER
5		*1	*D5525-3	*FLOAT SKIDTUBE
6		*1	*D5483-041	*TOW CAP ASSY.
7		*1	*D5484-041	*AFT CAP ASSY.
12		*18	*D5518-1	*CROSSBOLT SPACER
13		*6	*AN3C5A	*BOLT
14		15	AN3C44A	BOLT
15		*6	*NAS1149C0332R	*WASHER
16		15	MS21043L3	NUT
30	1		D5466-1	SADDLE, FWD INSIDE
31	1		D5467-1	SADDLE, FWD OUTSIDE
32	1		D5468-1	SADDLE, AFT OUTSIDE
33	1		D5469-1	SADDLE, AFT INSIDE
34	16		AN4C6A	BOLT
35	28		MS21043-4	NUT
36	32		NAS1149C0432R	WASHER
37	32		D3672-3	PHENOLIC WASHER
38	8		AN4C52A	BOLT
39	24		D5446-1	BUSHING
40	8		AN6C12A	BOLT
41	8		NAS1149C0632R	WASHER
42	8		D3672-9	WASHER
43	2		D2876	SADDLE SPACER
44	2		D2877	SADDLE SPACER
45	4		D2747	SET SCREW
46	2		D3533-1	SET SCREW
47	4		AN4C7A	BOLT
50	1		D3407-047	TOW RING
51	2		D5482-3	ACETAL WASHER
52	1		D3456-1	WASHER
60	1		D3405-041	GHW LUG
61	1		D3405-043	GHW LUG
62	4		AN4C47A	BOLT
63	8		D5482-1	ACETAL WASHER
71	75**		NAS1149C0332R	WASHER
72	6		D5513-1	BUSHING
73	3		MS21043-3	NUT
74	13		AN3C46A	BOLT

*DENOTES PART IS INCLUDED WITH D5425-043 ASSEMBLY

**INCLUDES ADDITIONAL WASHERS TO COMPENSATE FOR VARIANCE IN STACKUP THICKNESS